

TPM CIRCLE NO :- 2	ACTIVITY	KK	QM	PM	JH	SHE	OT	DM	E&T
TPM CIRCLE NAME : Joshile	LOSS NO. / STEP								
DEPT :- Manufacturing Engg.	RESULT AREA	P	Q	DEF :- A	C	D	S	M	

CELL :-A351      CELL NAME:- Drum Change      MACHINE / STAGE :- VMC Machining      OPERATION :- Operation No. 50

**KAIZEN THEME :** To Reduce the Tooling Cost Per Component in Drum Change Cell.

**IDEA :-** Op. 50 Insert CPC should be < INR 0.57

**WIDELY/DEEPLY:-**

**COUNTERMEASURE:-** Changed the Tool on Operation No. 50 VMC Machine as per below said details to get low Tooling Cost Per Component because of excess life of new Inserts comparatively than existing inserts.

<b>BENCHMARK</b>	3.19 INR
<b>TARGET</b>	2.78 INR
<b>KAIZEN START</b>	25.12.2013
<b>KAIZEN FINISH</b>	20.01.2014

**PROBLEM / PRESENT STATUS :-** Present Tooling Cost Per Component is INR 3.19-

**Tool Ceratizit-** OFHT 0403055N - M50 CTC 3215

**TEAM MEMBERS :-**  
Appasab Magadum, Praveen Jannu  
Pradeep Kinni

**Tool Sandvik –** INS R390-11T3-02 PM 1030



BEFORE

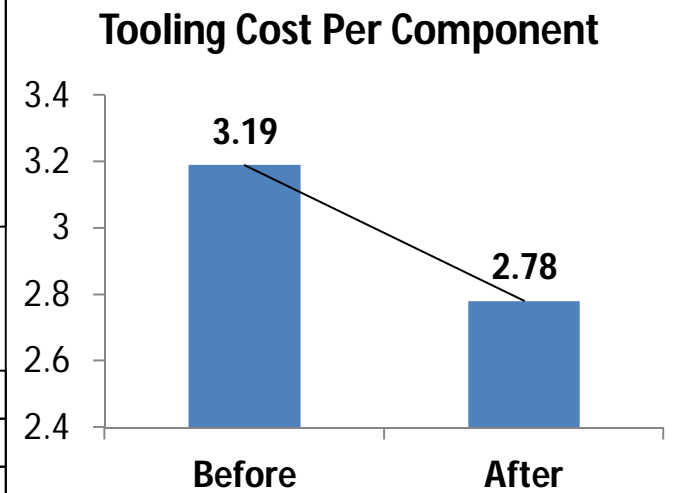


AFTER

**BENEFITS :-**  
1. Save INR 3,06,473 cost /Annum.

**WHY - WHY ANALYSIS :-**  
**Why1:** Tooling CPC is INR 3.19/-  
**Ans.1:** Op. 50 Insert CPC is INR 0.57-

**RESULT :-**



**KAIZEN SUSTENANCE**

**WHAT TO DO:** Changed the Insert Make in PCP & Tooling Master List.  
**HOW TO DO:**-----  
**FREQUENCY :** 1 Time activity

**ROOT CAUSE :-** Op. 50 Insert CPC is INR 0.57/-

**COST INCURRED FOR MAKING KAIZEN**

MATERIAL COST IN RS	LABOUR COST IN RS	TOTAL COST IN RS
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**REGISTRATION NO. & DATE:** 02 & 20.01.14

**SCOPE & PLAN FOR HORIZONTAL DEPLOYMENT**

**REGISTERED BY :-** Guru Basappa

SR. NO.	CELL	TARGET	RESPONSIBILITY	STATUS
1.	A351 – 2 <sup>nd</sup> Cell	28.01.14	Appasab	Comp.

**MANAGER'S SIGN :-** Ravi Gouda